

Work Order ID 86161

86161

Page 1

Jun-21-12 10:05:41 AM

Item ID: D119-675-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step RH

Start Date: 21/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/21

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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N/A	Rev N/A
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100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP 119-675-012 CHG004

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS 16 12/6/17 JB

MLJ 12-6-29

4

30

4

12/06/29 JB

DAS 16 12/6/17

4 RM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86161***86161***

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Item ID: D119-675-012

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step RH

Start Date: 21/06/2012 Start Qty: 4.00

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4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-675-012
Location: 70

140

0.00

140

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

6/21/12 (4)12/7/18 J

ME

12-07-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 86161

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Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01
IPP Rev:E change to rev.b as per ECN1107 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3043-042 Manufactured No 110 Each 0.0000

D3043-042

Step Weldment RH, A119

D2182B032 Manufactured No 110 Each 10.0000

D2182B032

Rubber Cushion

D2274-2 Manufactured No 110 Each 759.0000

D2274-2

Radius Block

Location

ST402

73932

Loc Qty

10

10

Loc Code

**

73932

32

Location

ST007

78233

81958

83258

84199

85455

Loc Qty

759

2

96

210

251

200

Loc Code

81958

12/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

D2617-3 Manufactured No

110 Each

28.0000

D2617-3
Bushing

4 16 ✓
** 4x 86394 JB

Location

Loc Qty

Loc Code

FG

10

27991

10

ST012

18

76948

6

84008

12

12x84008

D2617-5 Manufactured No

110 Each

36.0000

D2617-5
Spacer

8 32 ✓
** 6x 86395 JB

Location

Loc Qty

Loc Code

FG

10

31756

10

ST012

26

81814

10

85423

16

10x81814
16x85423

D2732-032 Manufactured No

110 Each

0.0000

D2732-032
RUBBER CUSHION

12.01.17 4x 20987 JB

D3041-1 Manufactured No

110 Each

0.0000

D3041-1
Clamp

4 16 ✓
** 84000 JB

D3041-3 Manufactured No

110 Each

8.0000

D3041-3
Clamp

2 8 ✓
** 84001 JB 12/06/27

Location

Loc Qty

Loc Code

ST462

8

51114

8

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

D3042-1
D3042-1
Clamp

Manufactured No

110 Each

27.0000

4 16
**

16

JB

Location

Loc Qty

Loc Code

ST457

27

83999

27

264.0000

4 16
**

16

83999 JB

AN4-11A
AN4-11A
Bolt

Purchased No

110 Each

Location

Loc Qty

Loc Code

ST356

264

118706

14

120731

100

121243

50

121708

100

534.0000

8 32
**

32

121708

AN4-12A
AN4-12A
Bolt

Purchased No

110 Each

Location

Loc Qty

Loc Code

ST357

534

115422

4

119775

28

120423

477

121524

25

47 115422
28 119775
JB

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

AN4-15A

Purchased

No

110

Each

762.0000

16

✓

AN4-15A

Bolt

**

Location

Loc Qty

Loc Code

358

100

121652

100

GA

100

120449

100

ST358

562

118706

3

120422

1

121541

158

122141

400

121541

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

48

✓

AN960JD416

Washer

**

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

MS21042L4

Purchased

No

110

Each

2,691.000

48

✓

MS21042L4

Nut

**

Location

Loc Qty

Loc Code

ST300

2691

119075

116

121011

193

121444

2082

121652

300

121444

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011 <i>HELI-ACCESS-STEP™</i> , LH	11.5 lb 5.2 kg	- 32.4 in - 1.28 m	- 373 in-lb - 6.7 m-kg	121.3 in 3.08 m	1395 in-lb 16.0 m-kg
D119-675-012 <i>HELI-ACCESS-STEP™</i> , RH	11.5 lb 5.2 kg	+32.4 in +1.28 m	+373 in-lb +6.7 m-kg	121.3 in 3.08 m	1395 in-lb 16.0 m-kg

5.0 PARTS LIST:

Qty -011	Qty -012	Part Number	Description
X		D119-675-011	<i>HELI-ACCESS-STEP™</i> , LH
	X	D119-675-012	<i>HELI-ACCESS-STEP™</i> , RH
4	4	D2182B032	RUBBER CUSHION
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
8	8	D2617-5	BUSHING
4	4	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3042-1	CLAMP
1		D3043-041	STEP WELDMENT LH
	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
4	4	AN4-11A	BOLT
8	8	AN4-12A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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Revision: B

Date: 07.10.23